

Work Order ID 55454

January 19, 2010 9:26:01 AM

Page 1

Item ID: D2656-13

Accept

Revision ID:

Item Name: Wearplate

Start Date: 1/19/10 Start Qty: 12.00

Required Date: 1/25/10 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date: 10-1-19 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2656

Rev D

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2656 Dwg Rev: D Prog Rev: D 12-

Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B 10-1-26

B 10-1-26

=> 810667

(412)

P10 ->

W/O: 55454		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/07	#120	Took Qty x1 For inspection template	S	10/01/07	x1		S 10/01/07

Part No: D2656-13 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 1/25/10 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326; 2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME: 1:00 pm FINISH TIME: 1:30 pm OVEN TEMPERATURE: 320°F

0.00

0.00

SB 10/01/28

SB 10/01/28

SB 10/02/10

(12)

(+12)

(X12)

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Work Order ID 55454

January 19, 2010 9:26:01 AM

Page 3

Item ID: D2656-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 1/19/10 Start Qty: 12.00

Required Date: 1/25/10 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

BL 10-02-11

(12)

Quality Control

170

Identify as per dwg & Stock Location:

FP-20

0.00

JL 10/02/11

(12) 0

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

10/02/11

Quality Control

MF 10-2-11

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NOTE: Date & initial all entries

Picklist Print

January 19, 2010 9:26:05 AM

Page 1

Work Order ID: 55454



Parent Item: D2656-13

Parent Item Name: Wearplate

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP: F 02.10.25 Re-format LKJ/RF
IPP Rev:G Now on Waterjet 06-07-03 JLM

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			100	sf	151.1365	10.2000	11.5		



1010/1025 SHEET

542



130-1-26

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

151.1365

102684

1

103258

1.5

103788

2

103840

2

104184

1.54

104921

8.5

106069

2

106478

4

106671

1.46

107906

2

108275

3

109289

1.5

111410

120.6365

111410

13

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55454
Description: Wearshoe		Part Number:	D2656-13
Inspection Dwg: D2656 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	✓			
5.650	+/-0.010	5.650	✓			
9.150	+/-0.010	9.150	✓			
0.300	+/-0.010	.301	*			
0.300	+/-0.010	.304	✗			
0.040	+/-0.010	.038	✗			

Measured by:	AB	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-26	Date:	10/01/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.05	New Issue	KJ/JLM	
B	09.03.10	0.040 dimension added	KJ/DD	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

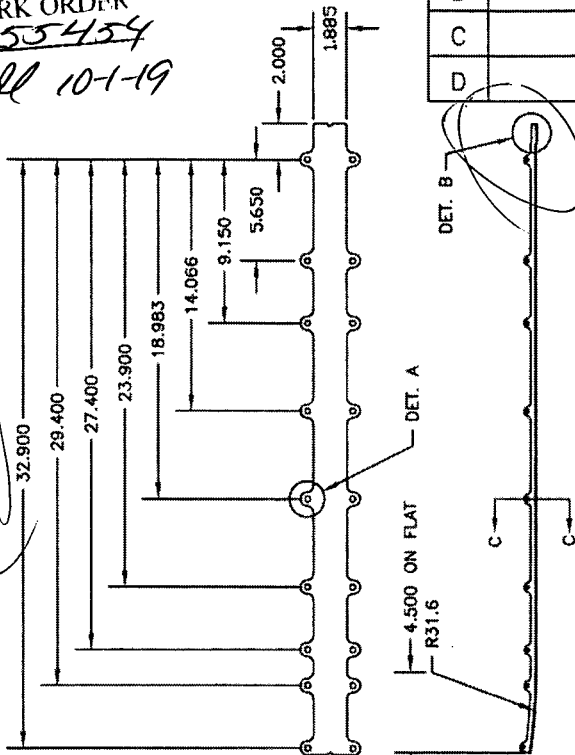
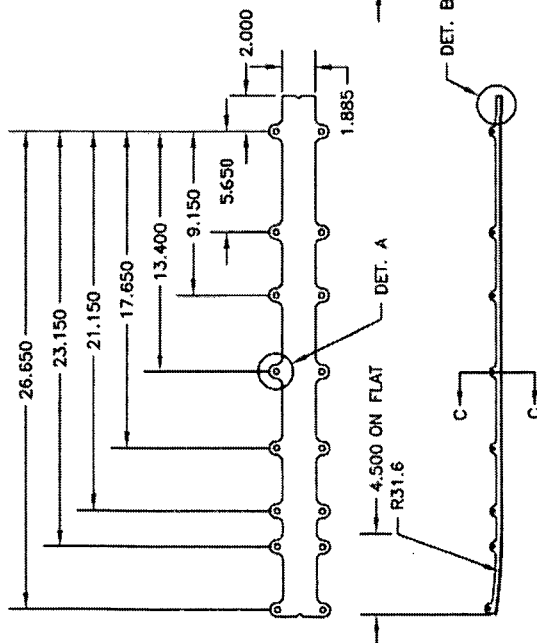
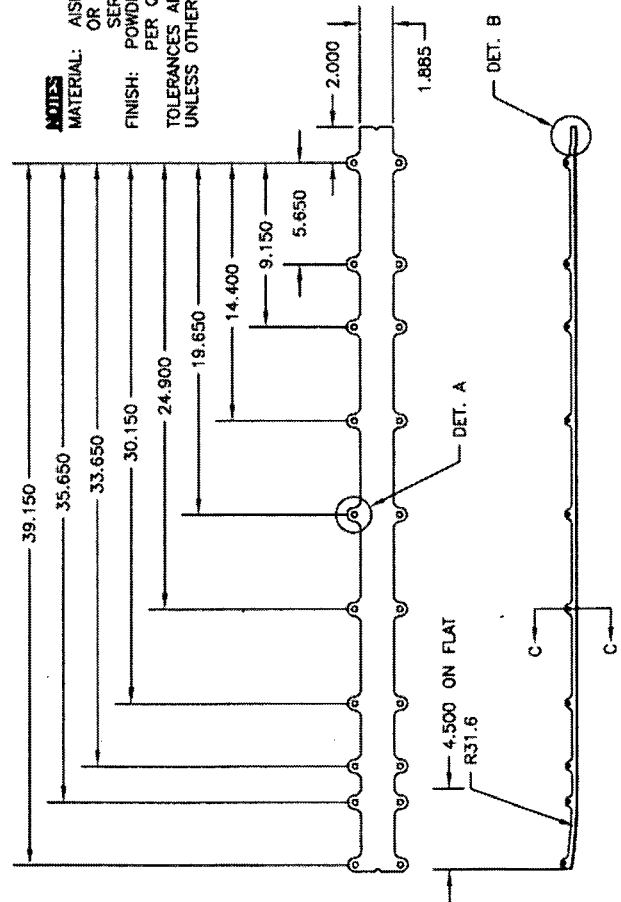
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NOTE: Date & initial all entries

DARTSHO
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDERNO. 55454

PL 10-1-19

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED		APPROVED		DRAWING NO. D2656
				REV. D SHEET 1 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

D2656-13**D2656-11****D2656-15****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANITEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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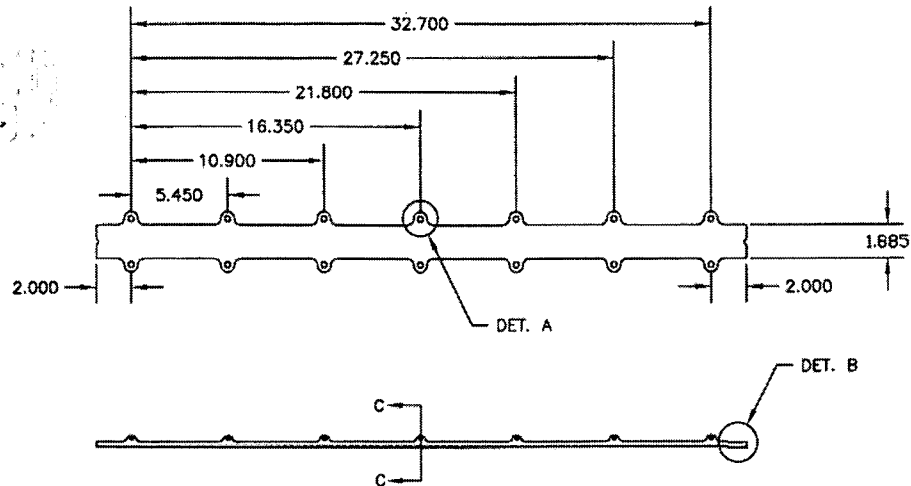
NOTE: Date & initial all entries



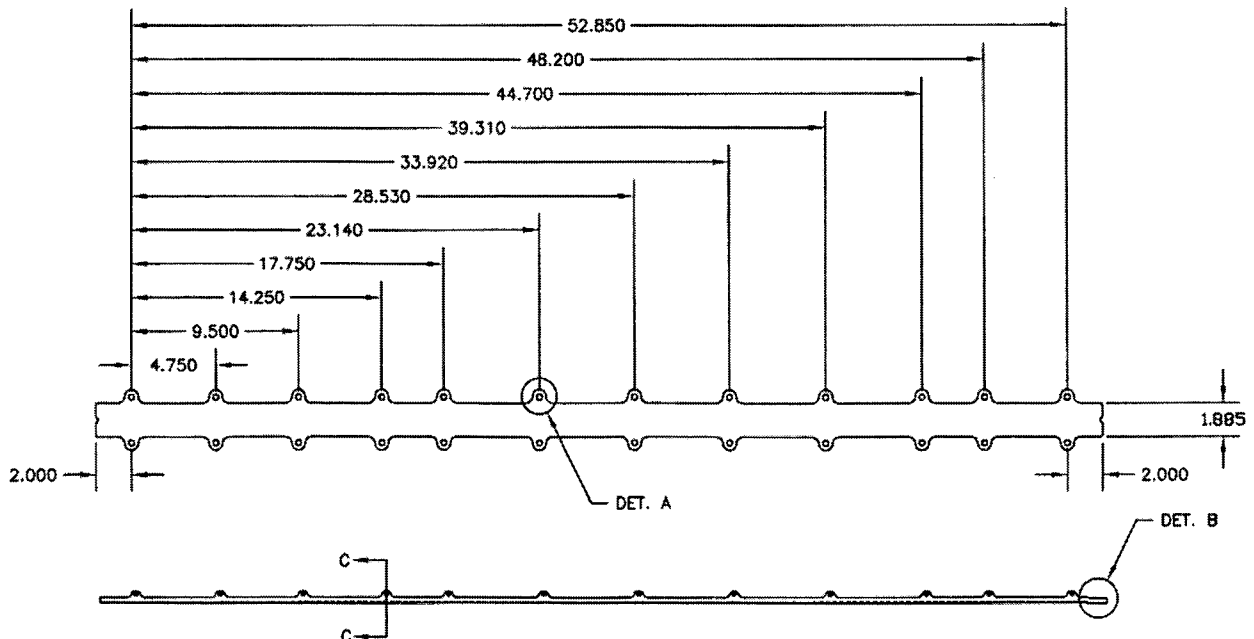
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-21

W/O 55454



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

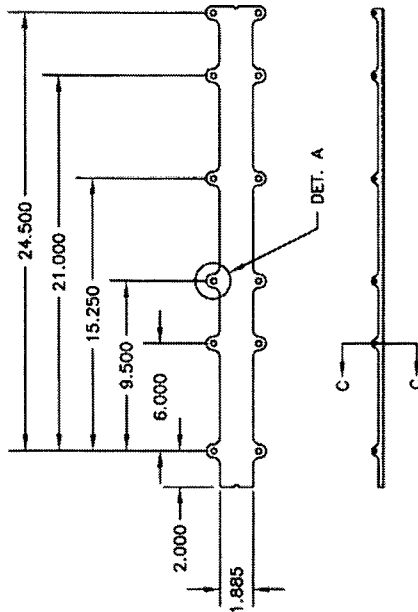
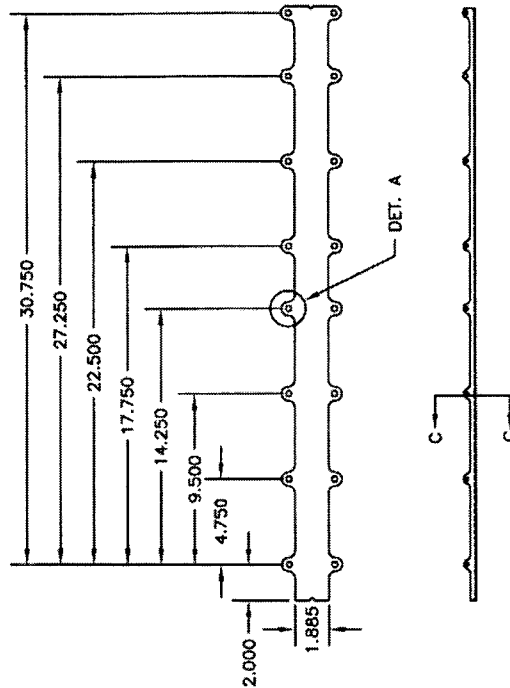
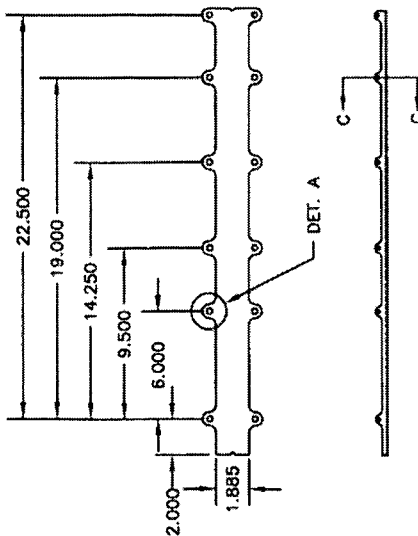
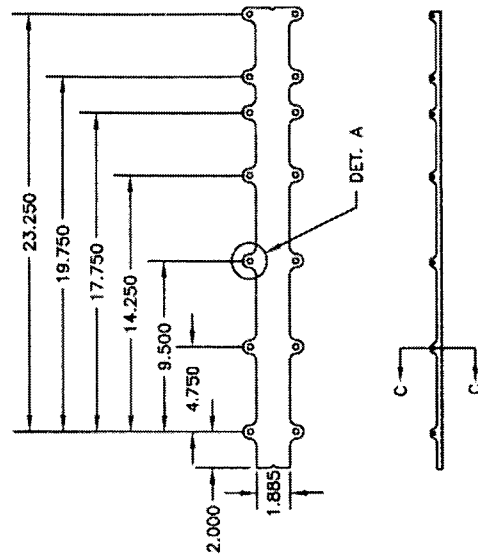
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CHECKED #	APPROVED #	DRAWING NO. D2656	REV. D SHEET 3 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33**D2656-37****D2656-31****D2656-35**

NOTES
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SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 016
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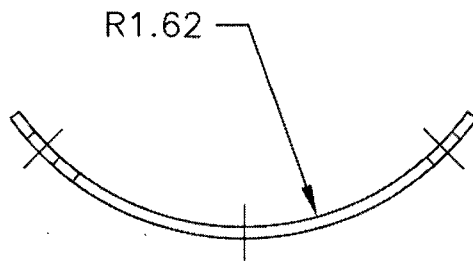
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

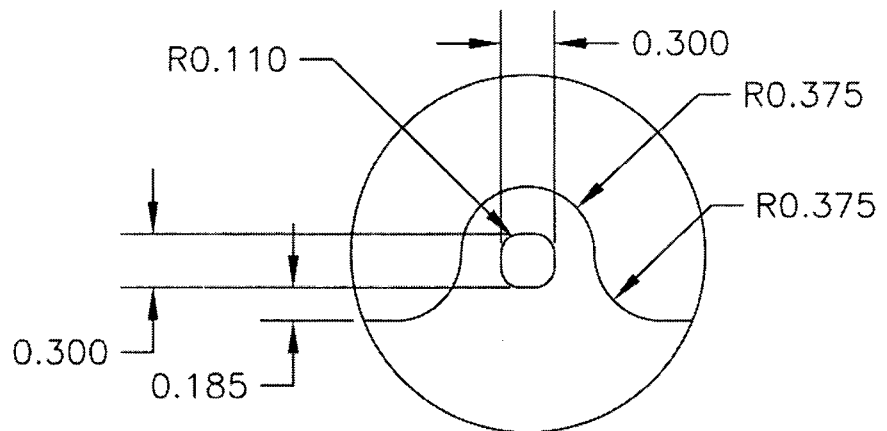
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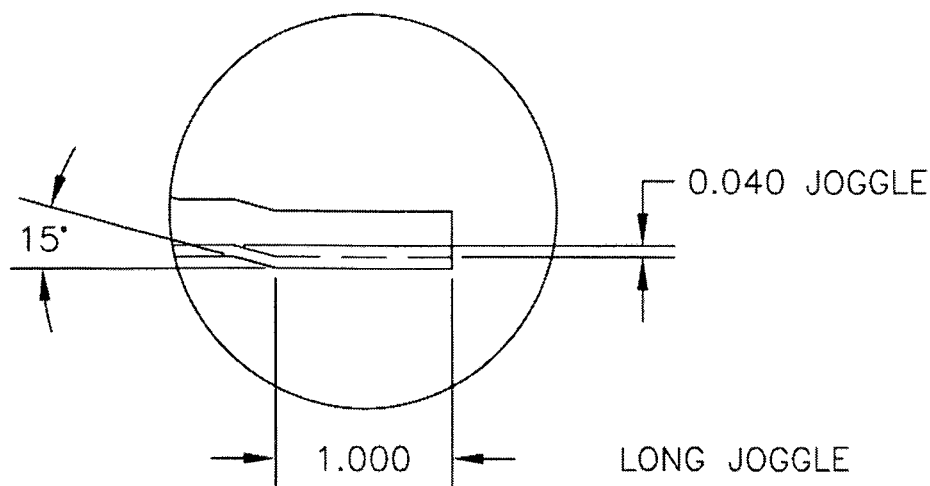
W/O 55454

05-09-06 *[Signature]*

DETAIL A



DETAIL B



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